Work Order ID 109373 Page 1 November-21-13 10:34:24 AM D3443-7 Item ID: D3443-7 Accept *N900040100* Setup Start B 109373 **Revision ID:** Stop Item Name: Tubing **Start Qty: 12.00 Start Date:** 11/21/13 **Cust Item ID:** Required Date: 12/05/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: MCJ Date: 13-1/-2 / Tooling: Approvals: Stop SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Work Center ID Description Number Stamp Code Qty Qty **Run Hours** Draw Nbr **Revision Nbr** D3443 Rev C 100 0.00 NC BRAKE *100* Brake NC 0.00 DAS 30 Brake NC 1- Form as per Dwg D3443 using DT81172- Deburr per dwg D3443 9-89 ***CUT 0.100" LONGER*** 0.00 110 Small Fab *110* Small Fab 0.00 Memo Small Fab GRIND RAD PER DWG DAS

120

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

27

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Work Order ID 109373 Page 2 November-21-13 10:34:24 AM Item ID: D3443-7 Accept *N900040100* Setup Start **Revision ID:** Item Name: **Tubing Start Qty: 12.00 Start Date:** 11/21/13 **Cust Item ID:** Req'd Qty: 12.00 Required Date: 12/05/13 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Approvals: Date: ____ Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Description Work Center ID **Run Hours** Code Qty Qty Number Stamp 130 0.00 CONVENTIONAL MILLING MACHINE *130* 0 12 Mill Conv 0.00 Memo 14.02.14 I- Mill end to lenght and drill hole as per dwg D34432-Deburr as per dwg Conventional Milling Machine D3443 QC2- Inspect parts off machine FAI/FAIB 0.00 140 *110* QC 0.00 Memo Quality Control 150 QC8- Inspect parts - second check 0.00

0.00

Memo

150

Quality Control

QC

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Work Ord November-21-1				*109	373*						Page
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Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ock Location: WA00	Set Up/ Run Hours i 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

0.00

Memo

Memo

QC21- Final Inspection - Work Order Release

160 Packaging

170

Quality Control

Packaging

170

QC

D14-02-18

Page 3

DAS 33 9-89

14-02-14

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Picklist Print

November-21-13 10:34:28 AM

Work Order ID: 109373

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Parent Item: D3443-7

Parent Item Name: Tubing

109373

D3443-7

Start Date: 11/21/13

Required Date: 12/05/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

A05.11.14New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	53.1606	0.75	10		N.	
M304TR0 304 ss round tube .750 x .120		120							**		FF	24-0	1-14
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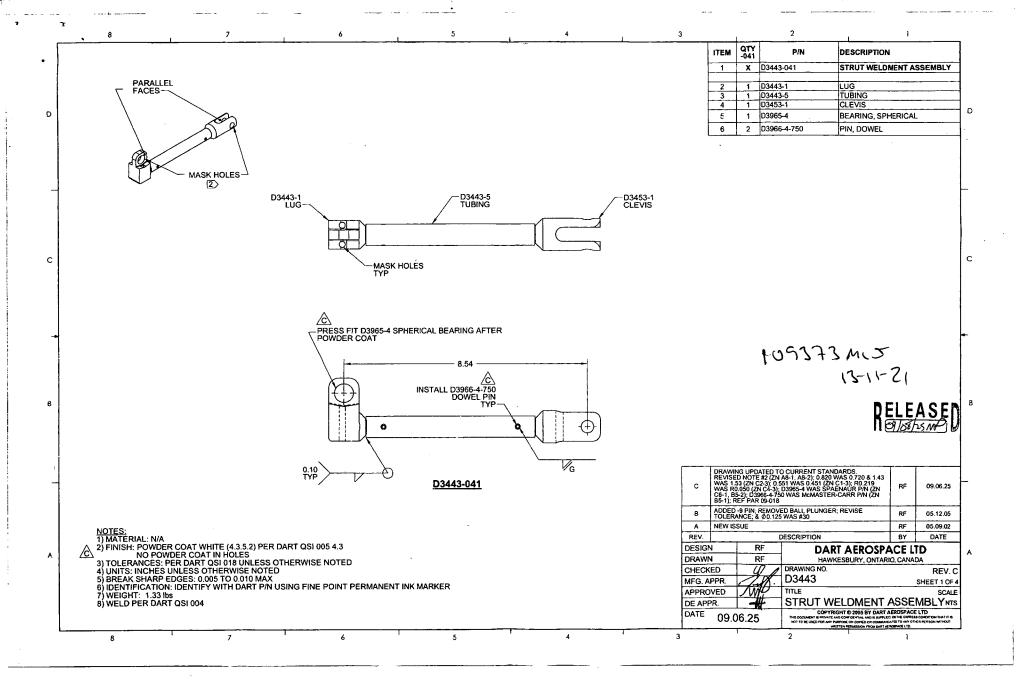
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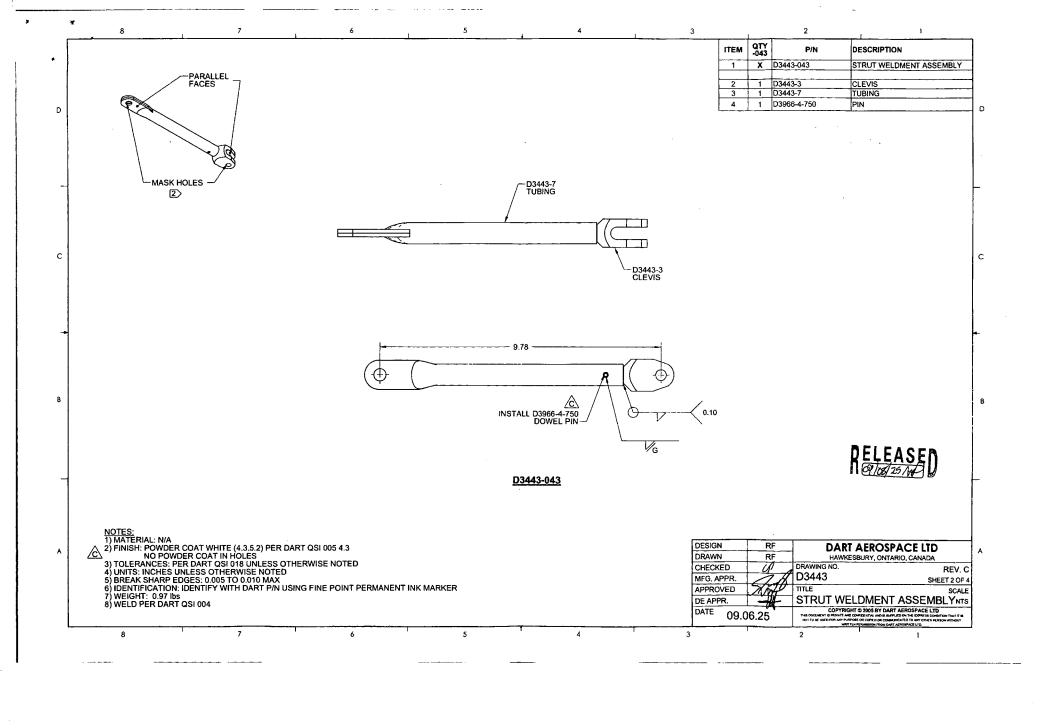
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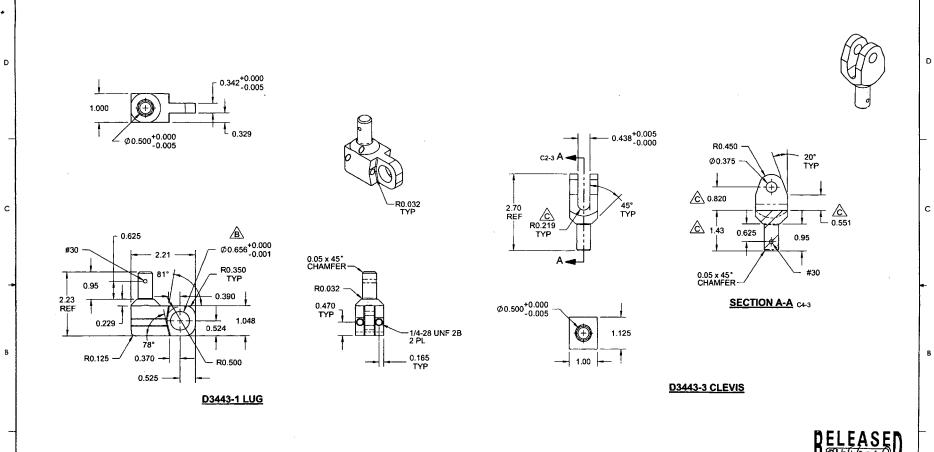
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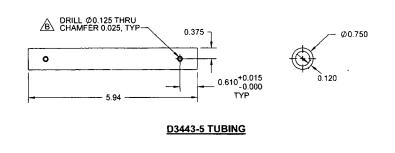
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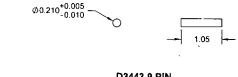


NOTES:
1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B) D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	W /	DRAWING NO. REV. C
MFG. APPR.	11	D3443 SHEET 3 OF 4
APPROVED	W.	TITLE SCALE
DE APPR.		STRUT WELDMENT ASSEMBLYNTS
DATE 09.0	06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD hts DOLWH I I B PRINTE AND COMPENSION OF EACH SEPTED ON THE COMPENSION THAT IT IS NOT TO BE USED FOR ANY HERMON OR ODDED OR COMMUNICATED TO ANY OTHER PRESIDENT WITHOUT

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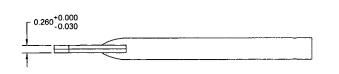




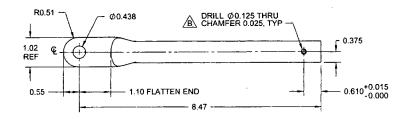
D3443-9 PIN

D3443-9 NOTES:

1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A







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U3443	-/	ıv	DI	N.O.

D3443-5/-7 NOTES:
1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120) 1) MATERIAL: AISI 316/304 33 SEMILES TO SELECTION (2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX 6) IDENTIFICATION: NONE 7) WEIGHT: D3443-5 = 041 lbs D3443-7 = 0.62 lbs

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DESIGN DART AEROSPACE LTD RF DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D3443 MFG. APPR. SHEET 4 OF 4 APPROVED TITLE SCALE STRUT WELDMENT ASSEMBLYNTS DE APPR. COPYRIGHT © 2005 BY DART AEROSPACE LTD

THIS DOCUMENT IS HOWEVER AND COMPOSITE AND IS SPELED ON THE EXPRESS CONCIDENT THAT IT IS

NOT TO BE USED FOR NOT HEAPES OR COMPOSITE TO DAY OTHER PERSON WITHOUT DATE 09.06.25

DQA:			Date:										TRAGE
			_			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE		ا فا		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
	-				_	Rework	1		Skid-tube Crosstube]	Water Jet	Engineering
Part N	No.					Scrap	1		Machining Small Fab	$\overline{}$	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Thern	noforming Finishing	3	Rec/Stor	e/Packaging	Other ,
NCR I	۱o.					Suspected Unapproved			Large Fab Composite	:[]	Supplier	
	_	···	1	-			ᆜ		A		C: 0	· · · · · · · · · · · · · · · · · · ·	
Root		D-4-	C4	04	Desci	ription of work order update	1	nitial	Action		Sign & Date	Verification	QC Inspector
Cause	-1	Date	Step	Qty		or non-conformance	Cn	ief Eng	Description		Date	verification	QC Hispector
Design Doc/Data	Н												
Equip/Tooling	Н								·				
Handling/Pre	\Box												
Material	Н		1										
Operator				•					·				
Offset/Setup	П						1						
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Unapproved													
							FA	ULT CA	regory		,		
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	Щ	Bending			<u> </u>	Bend	_	4	Program	<u> </u>	Outside Dim	 	Pressure/Forced
	Ш	Centre No	t Concer	itric	\vdash	BOM/Route	_	Grain		\vdash	Over/Under	_	Set-up
	Щ	Cracks				Broken/Damage/Defect	\vdash	Hardwa		-	Part Incorre	—	Temperature/Cure
	$\vdash \vdash$	Crimp/Kink/Ripple/Wave			 	Burrs	_	1 '	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
		Cuffs			-	Countaining	_	4	tions Incomplete/Unclear	\vdash	Part Moved	L Vrang	Wrong Stock Pulled
	Crushing				-	Countersink Cut Too Short	\vdash	1 1	gned/off center	\vdash	Positioned V Power Loss/		Other
	Heat Treat				\vdash	i	\vdash	Mislabe Misrea		<u> </u>	Trower ross/	Juige	Tottlei
	Inspection Strip in Tube				-	Drawing Drill Holes	\vdash	Off-set					
	Marks/Chatter				\vdash	Finish	-	4					
I	1	Turning Sequence Wave/Twist in Tube				IFINISh		IOut of	Calibration				

DART AEROSPACE LTD	Work Order:	
Description: Tising	Part Number:	3443-7
Inspection Dwg: 3443 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.02	±.03	1-073	v		Venu	BG 05
. 51	t-07	-500	~		h	
Ø.438	+-006	- 437	<u></u>		ν	1)
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- 760	+000	.758			4	7
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Measured by:	Re	Audited by:	40	Preliminary Approval:	
Date:	4.02.13	Date:	14/02/14	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

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